

Date: Thursday, 7/19/2007 2:27:45 PM
 User: Kim Johnston

Process Sheet

(5)

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
 Job Number : 33669
 Estimate Number : 10937
 P.O. Number : *N/A* Part Number : D29392
 This Issue : 7/19/2007 S.O. No. : *N/A* Drawing Number : D2939 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : MACHINED PARTS Drawing Revision : C
 Previous Run : 33473 Material : *N/A*
 Due Date : 7/31/2007 Qty: 10 Um: Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC
 Est Rev: C As per Rev C 07-03-19 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101001 7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 6.00" Grain Along 6.00" Length

Batch No: *323934* *mk 07/08/04* 10

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

5-Deburr

mk 07/08/04 10

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

mk 07/08/04 10

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



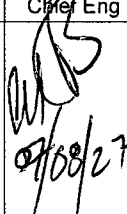
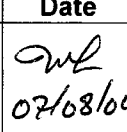


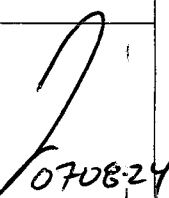
Comment: INSPECT ALL DIM TO DIM SHEET

mk 07/08/04 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/08/04	2	1 piece scrap, the piece was are .030" off on the "x" axis, the dimension .500" are .470" @ the bushing hole location.	 07/08/27	scrap and replace	 07/08/04		 07/08/27	 07/08/27

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 33669

Part Number: D29392

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD 07.08.16

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BL / Fd.

07/08/17 (10)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 105068

BL / M. 07-08-20

(10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

H/8/22 SD

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CP 07/08/22 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 07.08.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33669
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.127	0.128	0.128	0.126		
B	0.100	0.140		0.136	0.130	0.130	0.127		
C	0.100	0.140		0.114	0.116	0.188	0.115		
D	0.210	0.230		0.224	0.223	0.224	0.224		
E	1.245	1.255		1.249	1.249	1.250	1.249		
F	1.245	1.255		1.249	1.249	1.249	1.249		
G	2.495	2.505		2.499	2.499	2.506	2.506		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.578	1.576	1.576	1.576		
J	2.495	2.505		2.499	2.499	2.499	2.499		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.238	0.239	0.238		
N	0.100	0.140		0.121	0.121	0.122	0.121		
O	0.540	0.560		0.556	0.556	0.556	0.556		
P	0.490	0.510		0.503	0.502	0.502	0.501		
Q	3.715	3.725		3.717	3.717	3.717	3.717		
R	2.720	2.760		2.746	2.746	2.746	2.746		
S	0.240	0.270		0.253	0.256	0.256	0.255		
T	0.100	0.180		0.134	0.136	0.138	0.146		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.366	1.366	1.366	1.366		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.250	1.270		1.264	1.262	1.260	1.261		
Y	1.565	1.585	DT8695 A/B	1.577	1.574	1.574	1.573		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>ML</i>
Date:	07/08/04

Audited by:	SN
Date:	07.08.16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	33669
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.126	0.127	0.127	0.127		
B	0.100	0.140		0.128	0.127	0.128	0.128		
C	0.100	0.140		0.116	0.117	0.114	0.117		
D	0.210	0.230		0.224	0.224	0.224	0.224		
E	1.245	1.255		1.250	1.250	1.249	1.249		
F	1.245	1.255		1.249	1.250	1.249	1.249		
G	2.495	2.505		2.499	2.500	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.576	1.576	1.576	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		0.121	0.121	0.121	0.121		
O	0.540	0.560		0.550	0.551	0.550	0.551		
P	0.490	0.510		0.502	0.503	0.502	0.503		
Q	3.715	3.725		3.718	3.718	3.718	3.718		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		0.250	0.255	0.256	0.256		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.366	1.366	1.366	1.367		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.250	1.270		1.261	1.261	1.260	1.260		
Y	1.565	1.585	DT8695 A/B	1.574	1.573	1.574	1.573		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>ml</i>	Audited by:	<i>SP</i>
Date:	07/08/05	Date:	07.08.16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

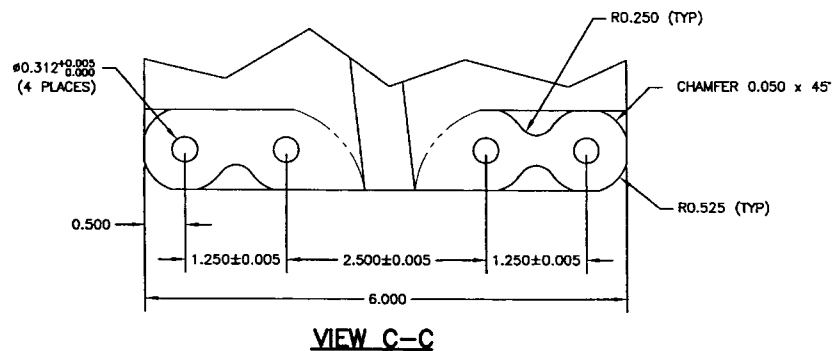
DART AEROSPACE LTD	Work Order:	33669
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

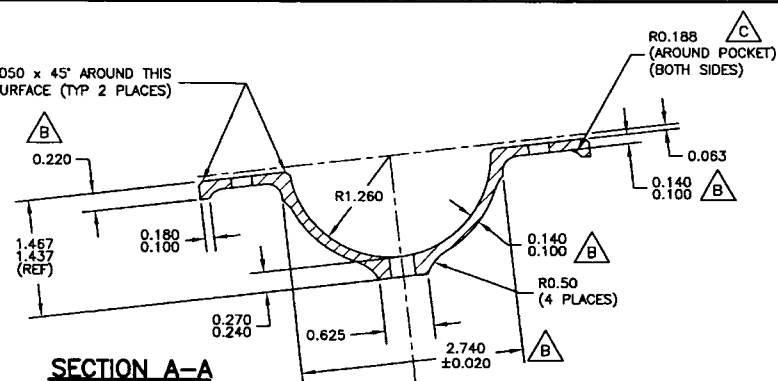
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.126	0.126				
B	0.100	0.140		0.126	0.126				
C	0.100	0.140		0.116	0.117				
D	0.210	0.230		0.224	0.224				
E	1.245	1.255		1.249	1.249				
F	1.245	1.255		1.249	1.249				
G	2.495	2.505		2.506	2.506				
H	0.510	0.515		0.510	0.510				
I	1.572	1.582		1.576	1.576				
J	2.495	2.505		2.506	2.506				
K	0.257	0.262		0.258	0.258				
L	0.312	0.317		0.314	0.314				
M	0.235	0.240		0.238	0.238				
N	0.100	0.140		0.121	0.121				
O	0.540	0.560		0.551	0.551				
P	0.490	0.510		0.503	0.501				
Q	3.715	3.725		3.718	3.718				
R	2.720	2.760		2.740	2.746				
S	0.240	0.270		0.256	0.256				
T	0.100	0.180		0.135	0.135				
U	1.625	1.635		1.628	1.628				
V	1.362	1.372		1.366	1.366				
W	0.316	0.321		0.320	0.326				
X	1.250	1.270		1.261	1.260				
Y	1.565	1.585	DT8695 A/B	1.573	1.573				
Z	0.178	0.198		0.188	0.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>gml</i>	Audited by:	<i>01.08.16</i>
Date:	07/08/05	Date:	SD

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>



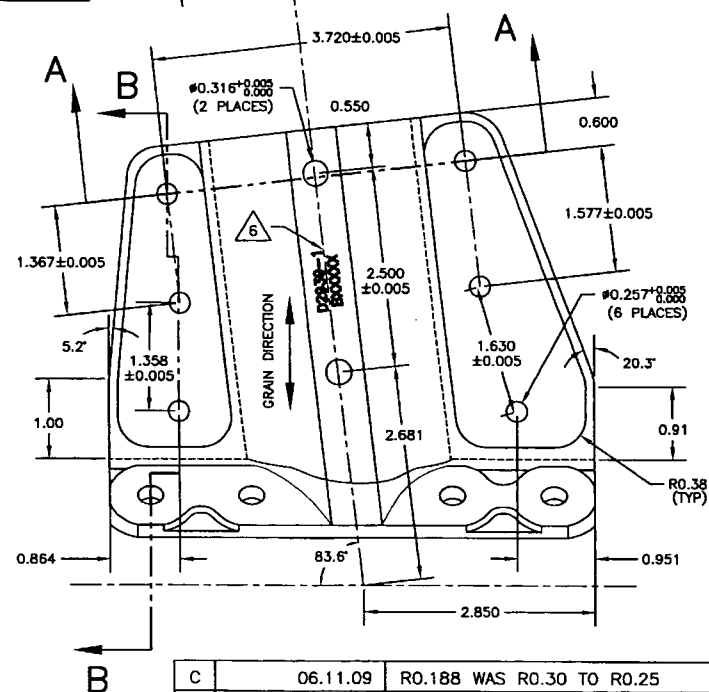
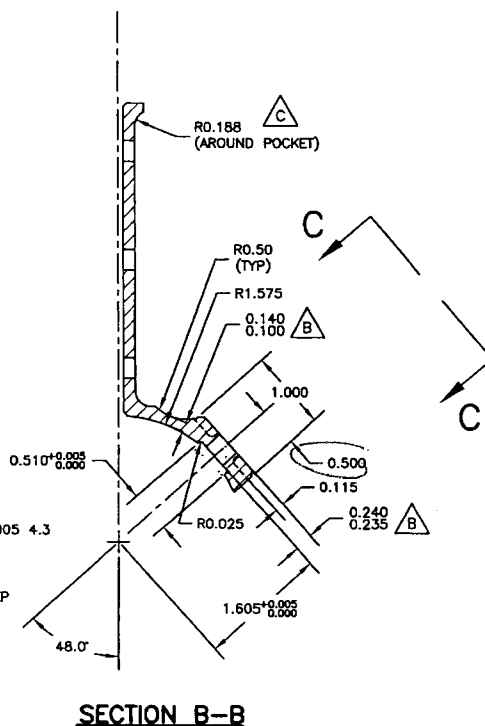
CHAMFER 0.050 x 45° AROUND THIS SURFACE (TYP 2 PLACES)



D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12) (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2939
DATE	TITLE	SADDLE INSIDE
06.11.09		

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DATE 06.11.09

TITLE SADDLE INSIDE

DRAWING NO. D2939

REV. C SHEET 1 OF 1 SCALE 2:3

NO. 33669
WORK ORDER
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SUBJECT TO AMENDMENT
RETURN TO
ENGINEERING
SHOP COPY

01.02.12 #